

Optima Acrylic Filler 411

FOR PROFESSIONAL USE ONLY

Description

Optima Acrylic Filler 411 is a 2 component, high build, fast drying acrylic filler developed for vehicle refinishes. It can be applied in thick layers with high application viscosity. It helps to eliminate the surface defects and deep scratches with its high filling power.



4 parts of Optima Acrylic Filler 411
1 parts of Optima Universal 2K Hardeners
1 parts of Optima Acrylic Thinners

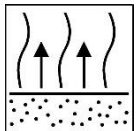


Spray Gun and Fluid Tip
Gravity feed, 1.6 – 1.8 mm

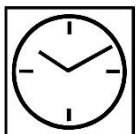
Application Pressure
1.7 – 2.2 bar at the air inlet
HVLP max.0.7 bar at the air-cap



Apply 2 – 3 single coats, allowing for 5-10 minutes flash-off time between coats.



Flash-off time between coats
5 – 10 minutes at 20°C.



3 hours at 20°C

30 minutes at 60°C



Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator

For detailed product information, read the entire Technical Data Sheet.

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Product and Additives

Acrylic Filler 411

Hardener Optima Universal 2K Hardeners

Thinner Optima Acrylic Thinners

Raw Materials

Optima Acrylic Filler 411: Acrylic resins
Hardener: Polyisocyanate resins

Suitable Substrates

Existing finishes
Steel
Polyester Surfaces
Washprimer 1K CF
Akripol bodyfillers

Substrate Preparation



Substrate cleaning: Before sanding, clean with suitable substrate cleaners to remove possible contaminations from the substrate. Wash the substrate with warm water and detergent before hand and rinse thoroughly.



Existing finishes:
Degrease and dry sand with P220 - P320 grit or wet sand with P400 grit.



Polyester putties:
Dry sand with P180 - P280 grit.

Steel surfaces:
Degrease and dry sand with P120 - P220 grit.

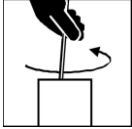


Substrate cleaning: Before applying , clean the surface by using suitable surface cleaning thinner to remove possible impurities.

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Mixing before application



Stir Optima Acrylic Filler 411 until homogeneous before use.

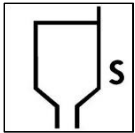
Mixing Ratio by Volume



4 parts of Optima Acrylic Filler 411
1 part of Optima Universal 2K Hardeners (Fast / Slow)
1 part of Optima Acrylic Thinners (Fast / Standard / Slow)

Use mixing stick.

Viscosity



30 seconds at 20°C (DIN 4)

Spray gun fluid tip / Application pressure



Spray Gun
Gravity feed

Fluid Tip
1.6 – 1.8 mm

Application Pressure
1.7 – 2.2 bar at the spray gun air inlet
HVLP max.0.7 bar at the air-cap

Pot life

35 mins after mixing at 20°C

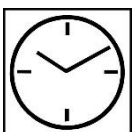
Application process



Apply 2-3 single coats, allowing for 5-10 minutes flash-off time between coats.

Flash-off time depends on the temperature and air flow.

Drying time



Fast hardener

Dry sanding
20°C 3 hours 60°C 30 min.

Wet sanding
20°C 3 hours 60°C 30 min.

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Final sanding



Final sanding step P500



Final sanding step P1000



Remove contamination using an appropriate cleaner

Recoatable with

All AkzoNobel Kemipol basecoats and 2K topcoats.

Film thickness

~50 µm film per coat.

Theoretical material usage

The theoretical material usage is 8 m²/l. at 50 µm (ready to spray mixture).

Note : The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances

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Cleaning of equipment:

Akripol Super Cellulosic Thinner

Product storage

Product shelf-life is determined when products are stored unopened at 70°F / 20°C.
Avoid extreme temperature fluctuation.

- *Product shelf life data see TDS S9.01.02*

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HEALTH & SAFETY DATA concerning Optima Acrylic Filler 411 and additives:

For professional use only.(See Material Safety Data Sheet). See text on the label of this product. The user of this product is required to comply with the national statutory regulations for health and safety at work and waste disposal.

The effectiveness of our systems is based on laboratory research and many years' practical experience. We guarantee that the quality of the work performed according to our system meets the AKZONOBEL KEMİPOL A.Ş standards, provided that our instructions are carefully followed and the work is performed in accordance with the requirements as to good craftsmanship. We decline any responsibility if the final result is affected by factors beyond our control. The customer has to determine the suitability of the delivered products for the intended application by using the means which normally are at his disposal.

<http://optima.akripol.com.tr/>

AKZONOBEL KEMİPOL A.Ş. İzmir, TÜRKİYE